

**Work Order ID 70488**

Thursday, June 09, 2011 3:18:38 PM

Page 1

Item ID: D206-642-151

Accept

Setup Start

Revision ID:

Item Name: Replacement Skidtube

Stop

Start Date: 6/9/2011 Start Qty: 1.00

Required Date: 6/20/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

N

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-151

CHG001

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐ M112860/M115778

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

3 DL 11/07/07

BE 11/07/07

BE 11/07/07

BE 11/07/14

**Dart Aerospace Ltd**

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Thursday, June 09, 2011 3:18:38 PM



Page 3

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NumberInsp.  
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

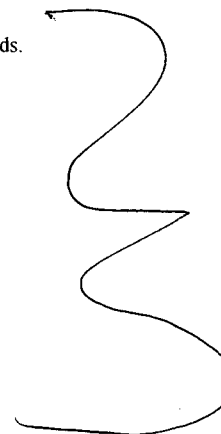
13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.  
\*\*\*\*no wearplate holes for this skidtube\*\*\*\*

17-Deburr tube and blow out chips from inside the tube



120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/10/13

**Dart Aerospace Ltd**

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Page 4

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Run Start

Stop

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140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

BE 11/07/18

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

0

BE 11/07/19

160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

1

0

BE 11/09/12

**Dart Aerospace Ltd**

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Page 5

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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

D2654-1  
2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting  
Start Date: 11/09/13 Time: 4:30  
Finish Date: 11/09/13 Time: 1:00

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch  
A/R ☐ Sikaflex-291 ☐ 116393 ☐  
Sikaflex expire date: 12/04/05

BE 11/09/13

**Dart Aerospace Ltd**

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Thursday, June 09, 2011 3:18:38 PM

Page 6

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

0.00 8 u105/11

QC

Memo

Quality Control

**Dart Aerospace Ltd**

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Thursday, June 09, 2011 3:18:38 PM

Page 7

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Stop

Sequence ID/  
Work Center IDOperation  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

BE 11/09/19

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☒ M12860

BE 11/09/19

3-Grind welds flush as per Dwg D3804.

DR 11/09/19

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ NONE BE 11/09/19

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP

11-9-21

**Dart Aerospace Ltd**

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Thursday, June 09, 2011 3:18:38 PM

Page 8

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Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210



HandFinish

Hand Finishing

HandFinishing

Memo

Install D2680-041 Nut Plate as per Dwg D3804

0.00

0.00

DD

11-9-21

220



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

11-09-22

QC 10

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

22  
6/10/22

**Dart Aerospace Ltd**

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Thursday, June 09, 2011 3:18:38 PM



Page 9

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



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240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-9-26

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50  
320 OF  
2:20

1X Ø M-11/09/26

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d M 11/10/03

**Dart Aerospace Ltd**

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Plan  
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NumberInsp.  
Stamp

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 0 11/10/03

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive  
A/R ☐ Sikaflex-291 ☒ 11/18/393  
Sikaflex expire date: ☐ 12/05

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4  
Batch: 11/18/315

1 0 11/10/04

**Dart Aerospace Ltd**

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Page 11

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QtyReject  
NumberInsp.  
Stamp

290

QC3- Inspect Part Finish

0.00

5 11/10/06



QC

Memo

0.00

Quality Control

300

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPP 1422

**Dart Aerospace Ltd**

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Page 12

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Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/18 [Signature]

MF  
11-10-18

**Dart Aerospace Ltd**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 09, 2011 3:18:44 PM

Page 1

Work Order ID: 70488

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube




Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No				Each	12.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG	B71616			12					
					62684			1					
					68135			1					
					68136			10					
D3286-1  Doubler		Manufactured	No				Each	36.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				36					
					52844			15					
					64563			21					
D2647  Cap		Manufactured	No				Each	30.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				30					
					55352			30					

11/07/11

BE 11/07/11

BE 11/07/07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 09, 2011 3:18:44 PM

Page 2

Work Order ID: 70488



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased No

Each

678.0000

52



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

678

115698

39

116471

139

117816

500



BE 6/9/13  
M117816 v52

D2654-1

Manufactured No

Each

0.0000

1



Web

D2649

Manufactured No

Each

207.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

195

68224

40

70394

155

LG001

12

65317

1

68507

11



BE 6/9/13  
B64562 v1  
BE 6/9/19  
B73390 v19

D3286-3

Manufactured No

Each

31.0000

2



Spacer

Location

Loc Qty

Loc Code

LG002

31

46643

1

64564

30



BE 6/9/11

2

Thursday, June 09, 2011 3:18:45 PM

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Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 09, 2011 3:18:45 PM

Page 3

Work Order ID: 70488

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each

581.0000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

579

117086

79

117849

500

Each

1,228.000

2

CR3212-4-03

Purchased

No



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1226

114859

1226

Each

36.0000

1

D2680-041

Manufactured

No



Nut Plate

Location

Loc Qty

Loc Code

ST020

36

55366

17

70088

19

Each

2.0000

1

D3805-041

Manufactured

No



Wearplate Assembly Fwd, Low Gear

Location

Loc Qty

Loc Code

FP

2

64565

2

B73013

X1

Thursday, June 09, 2011 3:18:45 PM

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Page 3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 09, 2011 3:18:45 PM

Page 4

Work Order ID: 70488



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3805-045 Manufactured No

Each 2.0000

1



u 11/10/05

Wearplate Assembly Aft, Low Gear

## Location

## Loc Qty

## Loc Code

FP 64566

2  
2

370878

u

AN3-37A Purchased No

Each 255.0000

7



u 11/10/03

Bolt

## Location

## Loc Qty

## Loc Code

ST353 205  
105425 69  
111668 136  
ST354 50  
117619 50

Each 0.0000

7

AN960JD10 NAS1149D0363J Purchased No



(x7) u 11/10/03

Washer

MS21042L3 Purchased No

Each 2,322.000

7



u 11/10/03

Nut

## Location

## Loc Qty

## Loc Code

ST300 2322  
116391 9  
116549 613  
117441 800  
117601 400  
117885 500

1118451

u

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Page 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 09, 2011 3:18:45 PM

Page 5

Work Order ID: 70488

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

Each 112.0000

14



11/10/03

Bushing

Location

Loc Qty

Loc Code

ST084

100

371837

x14

68247

100

ST088

12

64760

12

AN960JD416 NAS1149D0463J Purchased No

Each 0.0000

1



x118384



(x1) 11/10/03

Washer

D2651-1 Manufactured No

Each 248.0000

6



11/10/03

Plug

Location

Loc Qty

Loc Code

fpa

121

69018

121

FP-A

127

57869

7

66445

10

67263

12

67760

98

x6

D2651-3 Manufactured No

Each 576.0000

6



11/10/03

O-Ring

Location

Loc Qty

Loc Code

FP-A

576

61962

132

66956

444

x6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 09, 2011 3:18:46 PM

Page 6

Work Order ID: 70488

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

Each

61.0000

1



Handwritten: 11/10/02

Screw

Location

Loc Qty

Loc Code

FP-A

26

115460

26

ST292

35

115460

35

Handwritten: X1

D2646

Manufactured

No

Each

24.0000

1



Handwritten: 11/10/03

Aft Cap

Location

Loc Qty

Loc Code

FP006

23

62678

23

FP-4

1

69019

1

Handwritten: B71070

Handwritten: X1

MS27039-1-08

Purchased

No

Each

768.0000

2



Handwritten: 11/10/03

Screw

Location

Loc Qty

Loc Code

ST291

768

115108

468

117423

300

Handwritten: 1118378

Handwritten: X2

AN960JD10L

NAS1149D0332J

Purchased

No

Each

0.0000

2



Handwritten: (x2) 11/10/07

Washer

Handwritten: 1117087

Thursday, June 09, 2011 3:18:46 PM

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Page 6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



8166 + 8169 D

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 704788

11-06-9

RELEASED  
09.03.03  
per ECR 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

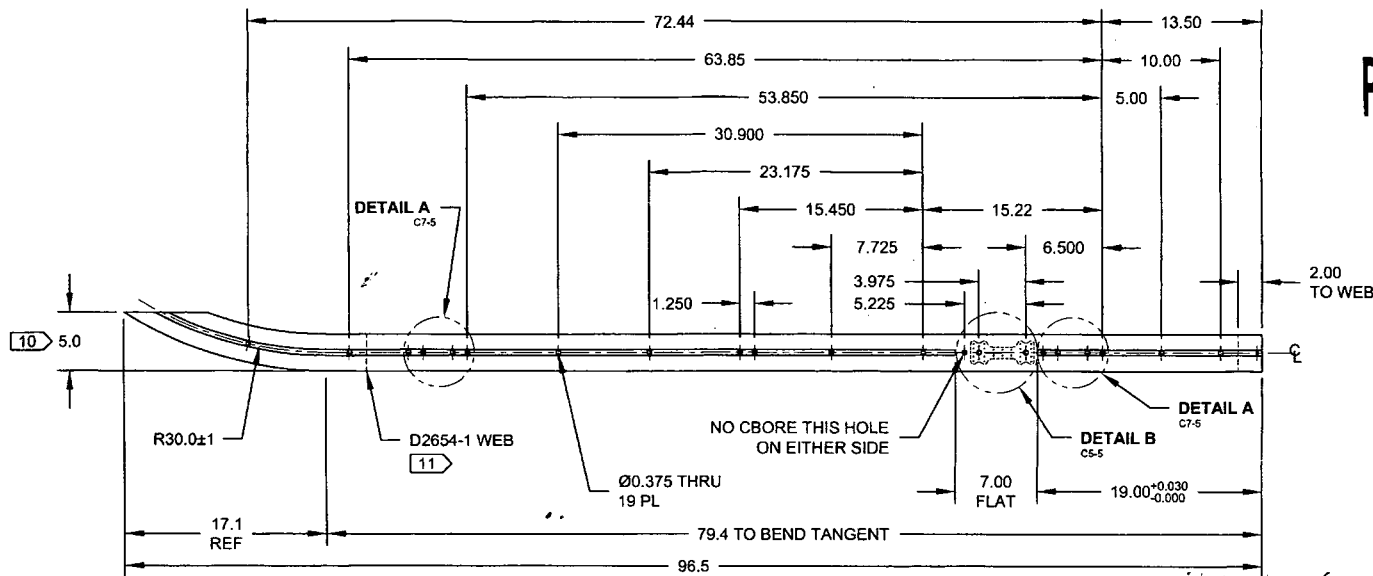
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

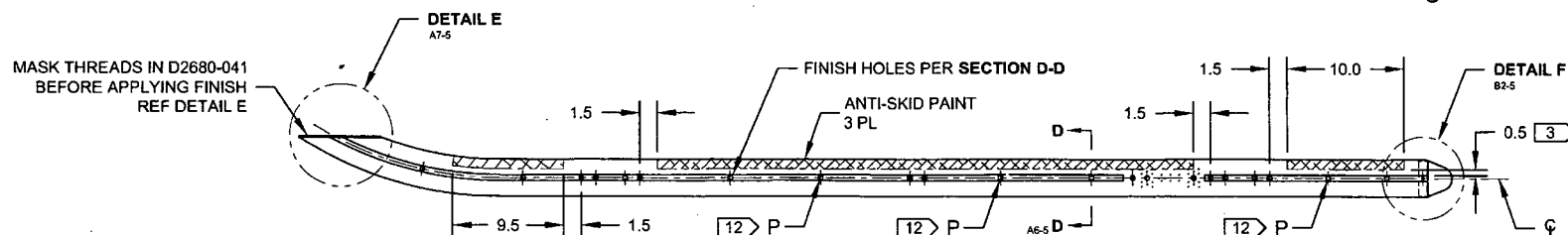


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09.03.07



**D3804-041 BENDING/DRILLING DETAIL**

*u/o 70488*



**D3804-041 ASSEMBLY/FINISHING DETAIL**

DESIGN	91	<b>DART AEROSPACE USA, INC</b>	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 2 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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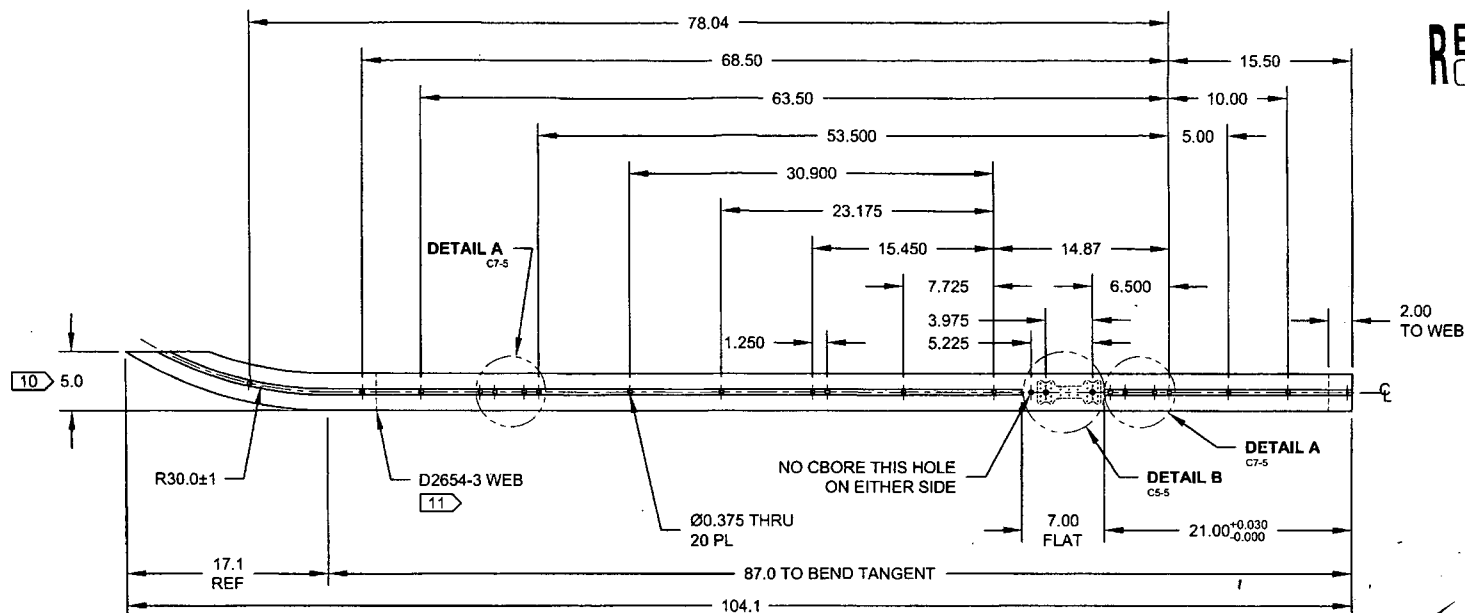
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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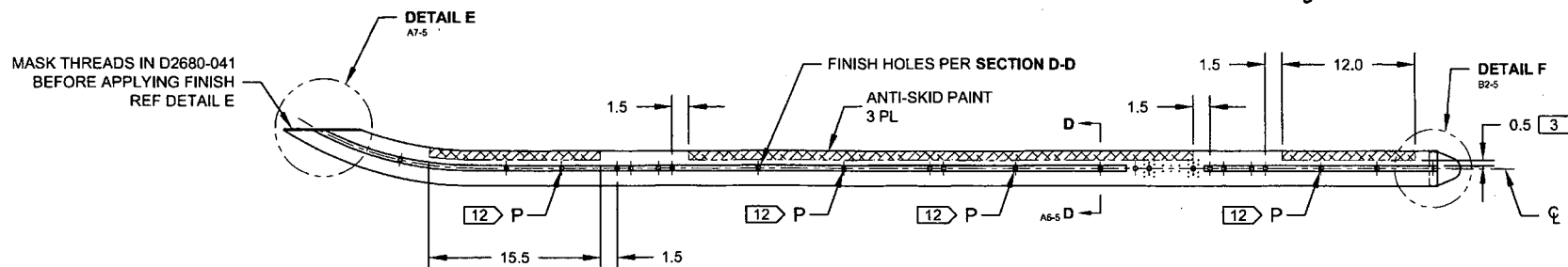
**NOTE:** Date & initial all entries

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09-09-03



**D3804-043 BENDING/DRILLING DETAIL**

*u/070488*



**D3804-043 ASSEMBLY/FINISHING DETAIL**

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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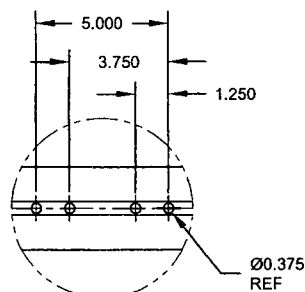
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

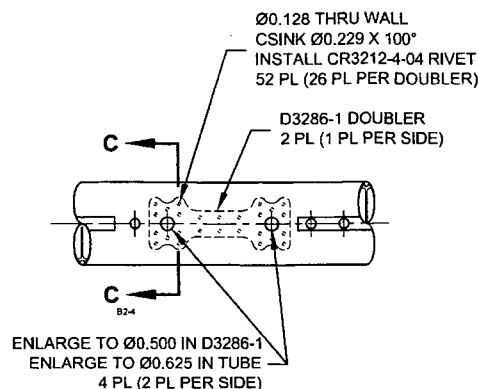
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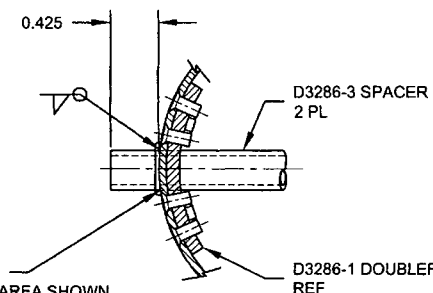
RELEASED  
UP 09.03.07



**DETAIL A** D6-2  
SCALE NONE C2-2  
D6-3  
C2-3

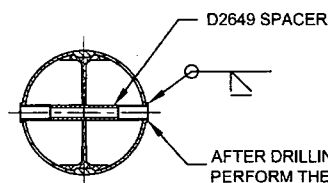


**DETAIL B** C3-2  
SCALE NONE C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C** C6-4  
PARTIAL SECTION  
SCALE NONE



**SECTION D-D** A4-2  
FOR Ø0.375 HOLES ONLY A4-3  
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBØRE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
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*u/070458*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

RELEASED  
97 09.03.03

CCR264SS3-3  
RIVET  
2 PL

CR3212-4-03 RIVET  
2 PL

**VIEW G-G**  
SCALE NONE

A7-5

D2647 CAP, TO INSTALL:  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS REQD)  
4. WELD D2647 IN PLACE  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE  
IN PLACE

MS27039-4-06 SCREW  
AN960JD416 WASHER  
D2680-041  
NUTPLATE

C7.5

1.0 REMOVE RIDGE ON  
INSIDE OF SKIDTUBE  
LEAVE 0.070 MIN.

**DETAIL E**  
SCALE NONE

B7-2  
B7-3

0.400

END OF WEB

SEAL WITH  
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204  
REF

MS27039-1-08 SCREW  
AN960JD10L WASHER  
2 PL

BORE OUT END  
OF SKIDTUBE  
TO 0.75 DEPTH  
AND 0.070 WALL

**DETAIL F**  
SCALE NONE

B2-2  
B2-3

WLO 70488

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries



NO. 266

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 704089  
Part number: 3206 642 151  
Description: 206  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Salv. Luis Date of Test Coupon 11-09-22

Welder Barclay Elliott Date of Test Coupon 11-09-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld